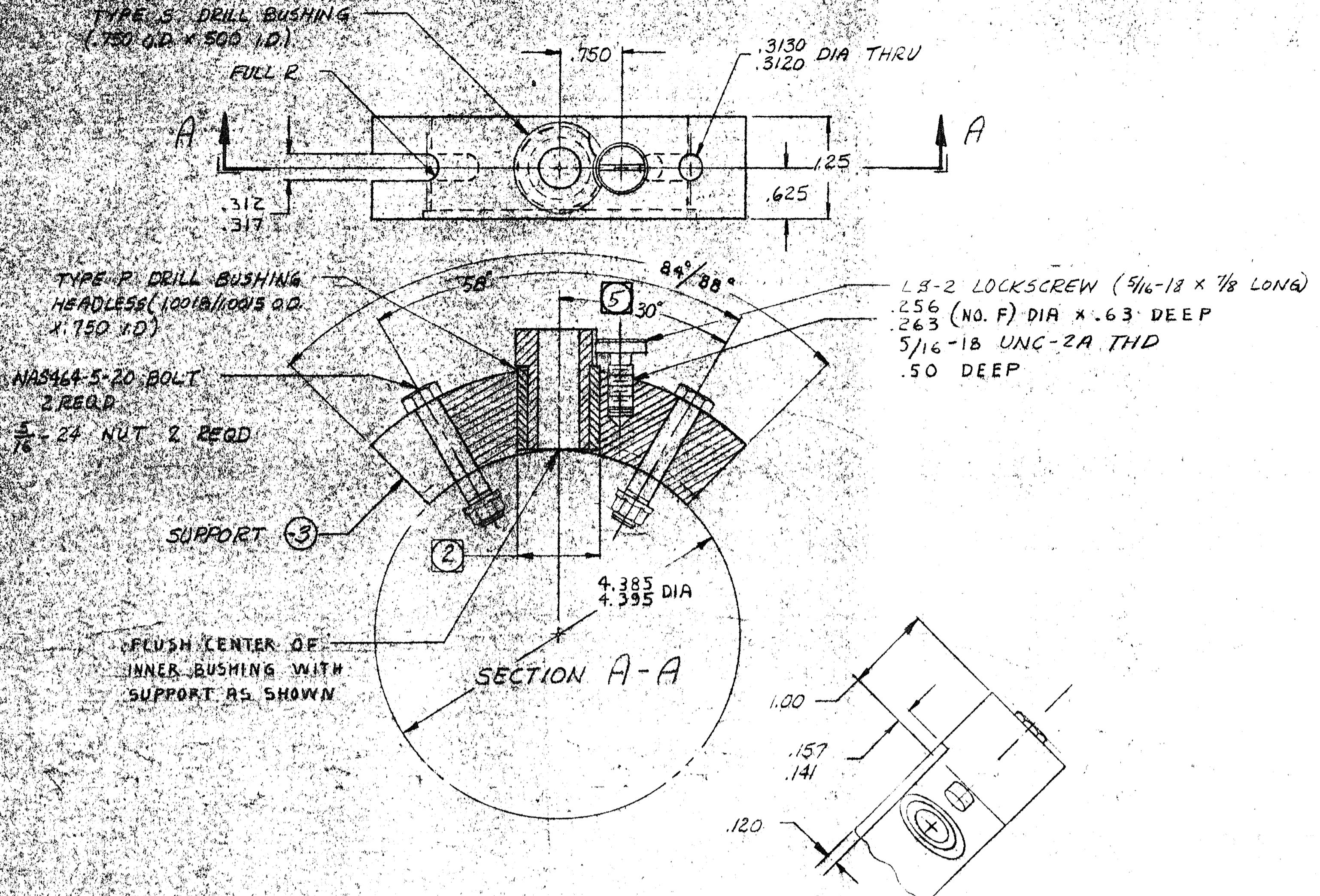


REVISIONS		DATE APPROVED	
ZONE	LTR	DESCRIPTION	DATE
		1. MAY BE REWORKED 2. SCRAP 3. RECORD CHANGE 4. OK TO USE	D SP
		RELEASED BY E.O. 126471	T.C.R. 3-20-74

D/7 A 1. REV. DIM. .312/.317 (WAS) .3130/.3120
2. DIM 84°/88° (WAS) 88°
3. ADDED TO S/N 7 "PARKERLUBBEZ PER HP4-7A
4. S/N 5 ± 0°-30° (WAS) ± 0°-0°-30°
5. ADDED ITEM # 010; ADDED S/N 8
RELEASED BY E.O. 126497



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(3) OPTIONAL: .500 O.D. x .250 I.D. x 1.38 LONG HEADLESS PRESS FIT DRILL BUSHING, PRESSED INTO THE .750 O.D. x .500 I.D. FLANGED DRILL BUSHING. MAY BE USED IN PLACE OF THE .500 O.D. x .250 I.D. FLANGED DRILL BUSHING.

7 BLACK OXIDE FINISH, OR PARCO LUBRITE PER HP4-7A -3 SUPPORT.

6 BREAK ALL EDGES .03 MIN.

(3) ANGLE TOLERANCE ± 0°-30°

(3) ONE FLANGED BUSHING SHOWN. INSTALL OTHER BUSHINGS PER REWORK PROCEDURES.

(3) MAY BE PURCHASED FROM VICTOR TOOL & SUPPLY CO., INGLEWOOD, CAL.

(3) MACHINE BORE TO 1.0013 DIA FOR BUSHING. ENLARGE BORE IN 100 INCREMENTS ON DIA AS REQD FOR LINE TO LINE BUSHING FIT IN SUPPORT.

BAG & TAG PARTS PER HP5-5. COAT ALL PARTS WITH PROTECTIVE OIL FILM PRIOR TO BAGGING.

NOTES UNLESS OTHERWISE SPECIFIED

FILE COPY

CODE IDENT	PART NO.	NAME	LIST OF MATERIAL	
			Critical Item	Non-Critical Item
011	1 010	TYPE 5 DRILL BUSHING - SLIP BENEATH	.750 O.D. X .312 I.D X 1.00	FLANGED STEEL
2 009	16-24	NUT		AMERICAN OR WELCH
1 008	LS-2	LOCKSCREW	5/16-18 X 7/8 (OR EQUIV)	
1 007	(8)	TYPE 5 DRILL BUSHING	.750 O.D X 250 I.D X 1.38	FLANGED STEEL
1 006	(8)	TYPE 5 DRILL BUSHING	.750 O.D X 250 I.D X 1.00	FLANGED STEEL
1 005	(8)	TYPE 5 DRILL BUSHING	.750 O.D X 250 I.D X 1.00	FLANGED STEEL
1 004	(8)	TYPE P DRILL BUSHING	1.0013-.1013 O.D X .750 I.D X 1.00	HEADLESS STEEL
2 003	NAS 464-5-20	BOLT	5/16-18 X 1.62	
1 002	-3	SUPPORT	4 1/2 X 2.00 X 1.25	CARBON STEEL
001	-1	DRILL FIXTURE		CMM

PROPERTY OF		APPROVALS
SCHWEIZER AIRCRAFT CORP. ELMIRA, NY		DRAWN BY KIRCHEN 2/1/74 CHECKED T.C. REYERSON 2-17-74 F4 Helibus 2-17-74 S4 Helibus 2/20/74 E4 Helibus 3/1/74
ITEM QTY MODEL		DIMENSIONAL TOLERANCES
REQD PER END ITEM		3 PLACE DECIMAL ± .010 2 PLACE DECIMAL ± .03 ANGULAR ± 0°-30° HS 217 APPLICABLE YES <input checked="" type="checkbox"/> NO <input type="checkbox"/>
NEXT USING DRAWING		EFFECTIVE ON
END ITEM NO. THRU		
CODE IDENT NO. DWG SIZE		
02731 D		SCALE 1/1 SHEET 1 OF 1
APPLICATION (USAGE) DATA		

DWG TITLE: DRILL FIXTURE - COUPLING, MIR TRAM OUTPUT SHAFT

DWG NO.: 269A9317

Hughes Helicopters division of summa corporation culver city ca. 90230

NOV 19 1974